

Date: Tuesday, 22/07/2008 9:14:13 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|-----------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | TOP PANEL ASS'Y |
| Job Number : | 40694 | | |
| Estimate Number : | 13135 | | |
| P.O. Number : | | Part Number : | D365011 |
| This Issue : | 22/07/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D3650 REV.B |
| First Issue : | 1/1 | Project Number : | N/A |
| Previous Run : | 39949 | Drawing Revision : | B |
| | Type : | Material : | |
| | SMALL /MED FAB | Due Date : | 29/07/2008 |
| Written By : | | Qty: | 6 Um: Each |
| Checked & Approved By : | <u>JW 08.7.22</u> | | |
| Comment : | Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|---------------------|
| 1.0 | M304S26GA * | 304/316 0.018 SHEET |
|-----|-------------|---------------------|



Comment: Qty.: 0.0193 sf(s)/Unit Total: 0.1159 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 105591 8-7-22

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3650

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

8-7-22

9

83 08/07/23

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8-7-22

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

8 08/07/23

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: Bend as per dwg D3650

83 08/07/22

9

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 22/07/2008 9:14:13 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANEL ASS'Y

Job Number: 40694

Part Number: D365011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/23 (X9)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: Store

PD 08-07-28 (9)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/30 (9)

Job Completion



MF 08-07-29

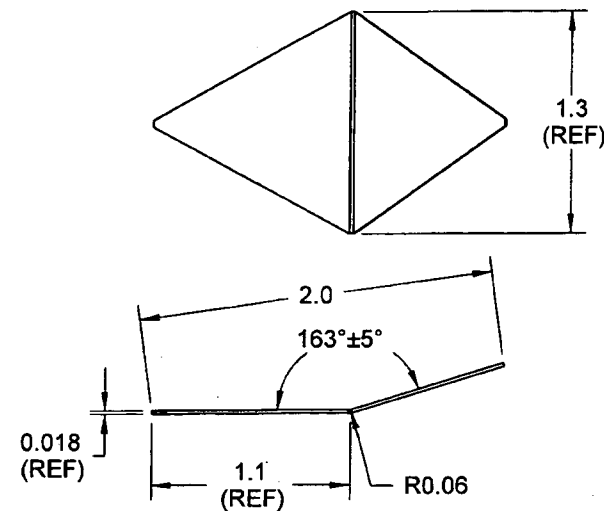
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

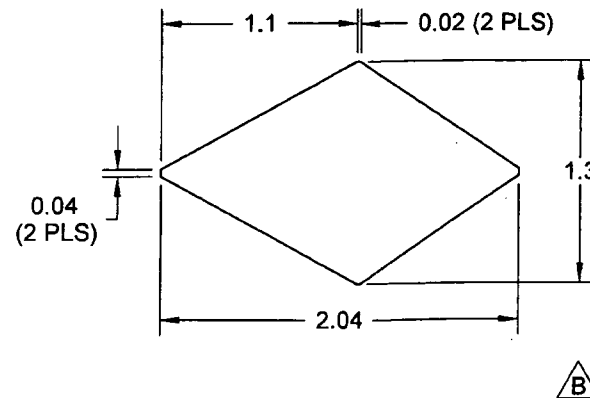
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

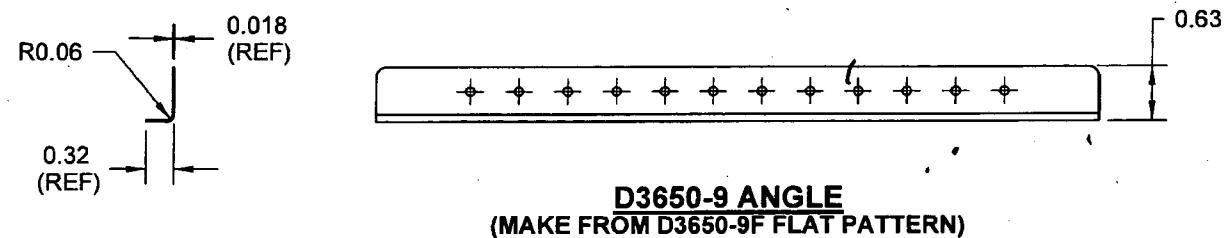
NOTE: Date & initial all entries



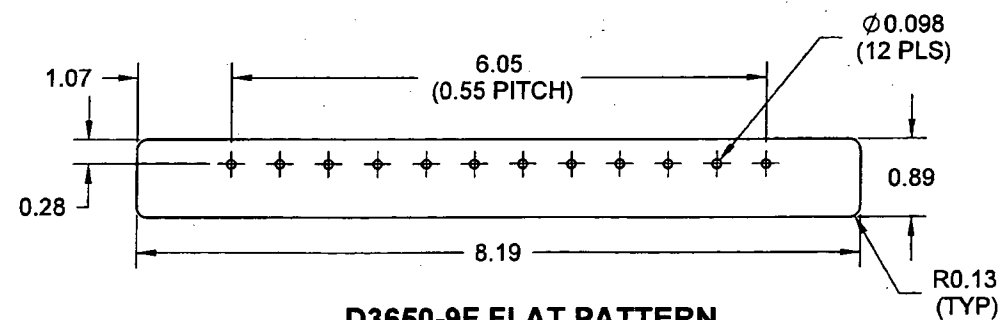
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



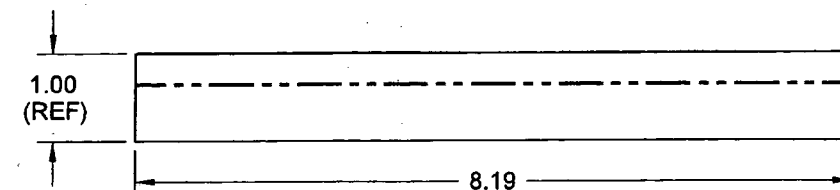
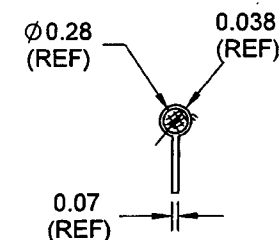
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-9F FLAT PATTERN



D3650-7-8.19 SEAL

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

| | | | |
|------------|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | LE | DRAWING NO. | REV. B |
| MFG. APPR. | MA | D3650 | SHEET 9 OF 9 |
| APPROVED | MA | TITLE | SCALE |
| DE APPR. | MA | TOP PANEL ASSEMBLY | 1:2 |
| DATE | 08.01.07 | <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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